

# Work Order ID 85282

June-05-12 11:34:57 AM

**\*85282\***

Page 1

Item ID: D3773-041

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Headrest Assembly

Stop **\*NS2\***

Start Date: 05/06/2012 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 19/06/2012 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/05 Tooling:

Date:

Run Start **\*NR1\***

QC:

Date: SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3773

Rev B

110

0.00

**\*110\***

Large Fab

Large Fab

Memo

0.00

Large Fab

1- locate top hole with a 3/16" dowel pin and tack weld D3773-1 adapter to D3773-3 leg as per dwg D3773 \*\*\*\*take dowel pin out before welding\*\*\*\*  
2- weld as per dwg D3773 QSI004  
316 S.S. Welding Rod Batch: M114509  
3- if necessary grind interior of D3773-3 leg flush after welding

(6)

EL 12-6-25

120

QC5- Inspect part completeness to step on W/O

0.00

**\*120\***

QC

Memo

0.00

Quality Control

CP 12-06-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 85282

June-05-12 11:34:57 AM

**\*85282\***

Page 2

Item ID: D3773-041

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Headrest Assembly

Start Date: 05/06/2012 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 19/06/2012 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC9- Inspect visual per QSI004- Fusion Welds

0.00

**\*130\***

QC

Memo

0.00

Quality Control

140

Identify as per dwg & Stock Location: SI 250A 0.00

**\*140\***

Packaging

Memo

0.00

Packaging

150

QC21- Final Inspection - Work Order Release

0.00

**\*150\***

QC

Memo

0.00

Quality Control

*5.7/6.7/6*

*6x*

*PL 15-06-26*

*6x*

*SP  
12-6-27*

*12/6/28*

*MF  
12-06-27*

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

# Picklist Print

June-05-12 11:35:01 AM

Page 1

Work Order ID: 85282

\*85282\*

Parent Item: D3773-041

\*D3773-041\*

Parent Item Name: Headrest Assembly

Start Date: 05/06/2012

Required Date: 19/06/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-05-21 new issue DD verified by:ec  
IPP Rev:B 08-07-18 revB as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3773-1 Manufactured No

\*D3773-1\*

Adapter

85264 x6

Location

Loc Qty

Loc Code

WA024

3

69942

3

D3773-3 Manufactured No

\*D3773-3\*

Leg

85283 x6

110 Each 0.0000 1 6

\*\*

ER 12-6-25

\*\*

a 12-6-25

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

8

7

6

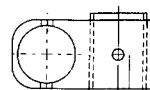
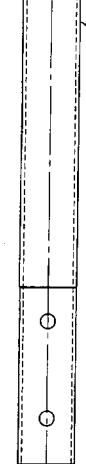
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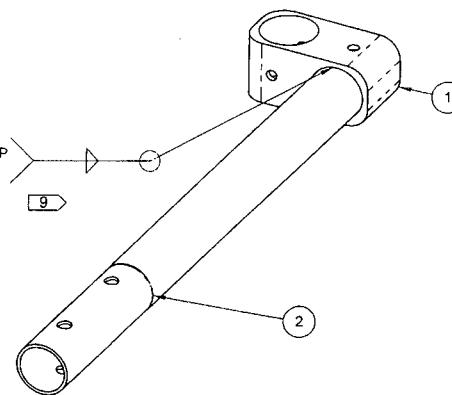
3

2

1

D3773-1  
ADAPTER  
REFD3773-3  
LEG  
REF0.13  
REF12.00  
REF

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. BS282 MLJ  
12/06/05

0.08 TYP  
2 PL

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	D3773-1	ADAPTER	1
2	D3773-3	LEG	1

## NOTES:

- 1) MATERIAL: SEE D3773-1/3
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3773-1, 0.40 lbs  
D3773-3, 0.69 lbs  
D3773-041, 1.04 lbs
- 8) WELD: PER DART QSI 004
- 9) IF NECESSARY GRIND INTERIOR OF D3773-3 LEG FLUSH AFTER WELDING

**D3773-041 HEADREST ASSEMBLY**

B	CHANGE HOLE SIZE TO 0.201	HS	08.06.24
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS		
DRAWN	HS		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.06.24		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3773** REV. B  
SHEET 1 OF 3  
TITLE **HEADREST ADAPTER** SCALE NTS

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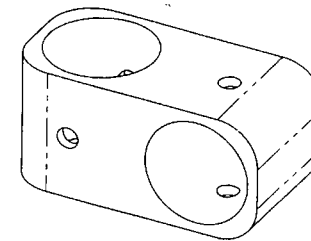
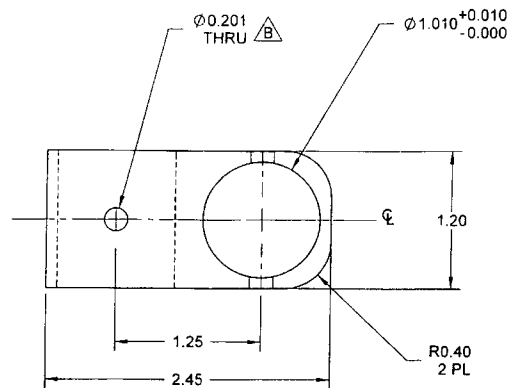
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

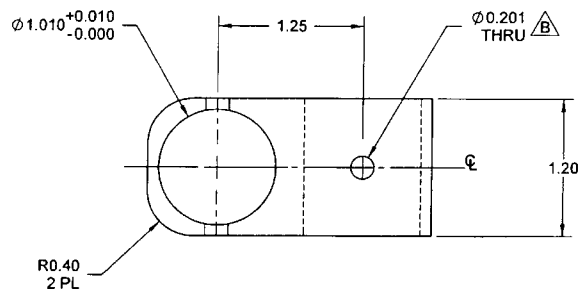
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**NOTE:** Date & initial all entries





05282



### D3773-1 ADAPTER

08-07-10

#### NOTES:

- 1) MATERIAL: AISI 304/316 SS BAR (REF DART SPEC M304B)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.40 lbs

DESIGN	HS	<b>DART AEROSPACE LTD</b>	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		<b>D3773</b>	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>HEADREST ADAPTER</b>	NTS
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W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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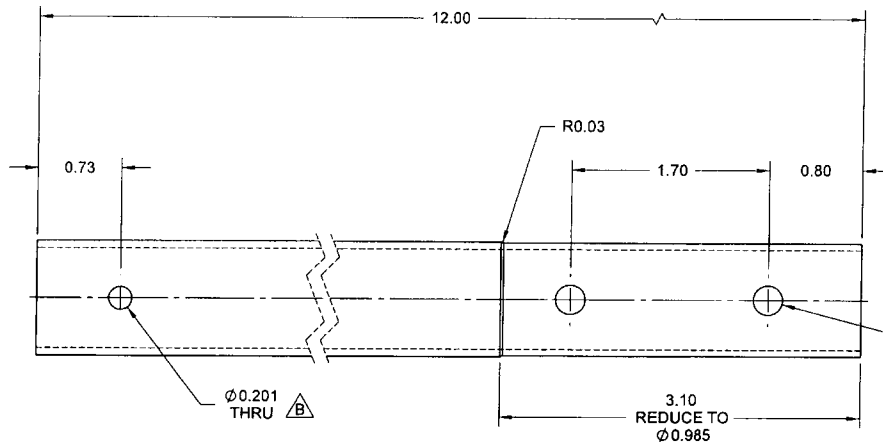
8 7 6 5 4 3 2 1

D

C

B

A



Ø 0.257  
THRU  
2 PL

Ø 0.985<sup>+0.000</sup>  
-0.010

Ø 1.000  
REF

0.065  
REF

**D3773-3 LEG**

25202



D

C

B

A

08-07-10 M/D

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS TUBING 1.00" OD X 0.065" WALL (REF DART SPEC M304TR1.000X.065)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.69 lbs

DESIGN	HS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	HS	DRAWING NO. <b>D3773</b>	REV. B
MFG. APPR.			SHEET 3 OF 3
APPROVED		TITLE <b>HEADREST ADAPTER</b>	SCALE NTS
DE APPR.			
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8 7 6 5 4 3 2 1

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